

**Work Order ID 54953**

Page 1

January 5, 2010 10:43:48 AM

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *PL*

Date: 10-1-05

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

S 10/02/01

Hj for MF 10/01/30

B54953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R: Aluminum Rod

10-Grind welds flush as per Dwg D2750

M 10/1/13

M112860

QE 10/01/14

M

10/1/14

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Page 3

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

12- Scribe batch# inside per dwg D2750

H 6/1/13

120

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

27 S106164

(XL)

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

27 S106164

(XL)

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

H 10/1/14

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Page 4

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev. Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*DD*

*10-1-14*

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals:

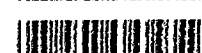
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

M 112395

exp. date: 12/3/30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod

batch:

M 112860

BE 10/1/12

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places perside) as per  
dwg D2750

H 10/1/14

HAWM

10-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 6

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- At section AJ-AJ drill out x-bolt spacer to 0.404"

BB 10/01/19

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00



⇒ Σ 10/01/20

QC

Memo

0.00



Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



⇒ Σ 10/01/20

QC

Memo

0.00



Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January 5, 2010 10:43:48 AM



Page 7

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

10-01-21

(X)

Ø

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:30 AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 12:00 PM

10-01-21

(X)

Ø

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

= 7 m. k 10/01/27

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 8

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220



HandFinish

HandFinishing

0.00

Memo

0.00

1- Install inserts as per Dwg D2750

⇒ M. K 10/01/27



230



HandFinish

HandFinishing

0.00

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH:

EXP DATE:

M 112345  
10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M 101223

5-Coat all exposed fasteners with "LPS Procyon" batch: M 104251

M. K

10/01/27

W/O:		WORK ORDER CHANGES					
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Page 9

January 5, 2010 10:43:49 AM

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

QC5- Inspect part completeness to step on W/O

0.00



⇒ Sublet

QC

Memo

0.00

(+U)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-09 sp

260

QC4- 100% Inspect kits for completeness

0.00



⇒ 8.10.02/01

QC

Memo

0.00

(+U)

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

W/O:		WORK ORDER CHANGES					
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Page 10

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Date:

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Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270



Packaging

Packaging

0.00

0.00

Rev A

10-2-8

SF

Memo

Package as per PPP D350-636-011

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/02/09 HJ

MF 10-2-9.

W/O:		WORK ORDER CHANGES					
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# Picklist Print

January 5, 2010 10:43:52 AM

Page 1

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3		Manufactured	No			230	Each	362.0000	8.0000			

O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 27

51613 27

Main Warehouse

ST 335

52562 335

D2744 Manufactured No

110 Each 60.0000 1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 60

44892 1

47488 23

51922 36

10/01/27  
8x M-2

10/11/13

W/O:		WORK ORDER CHANGES					
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Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	16.0000	1.0000			
Extrusion Bent												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

5

50675

5

Main Warehouse

ST

11

43495

1

47133

1

52346

9

D2743

Manufactured No

160

Each

299.0000

8.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

94

50281

50

51913

44

Main Warehouse

ST

205

44891

2

45555

17

48275

1

52310

185

8

BE 10/21/19

January 5, 2010 10:43:52 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
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Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739		Manufactured	No			160	Each	5.0000	1.0000			

350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47124

53900

5

1

4

160

Each

37.0000

4.0000



D3490-3

Manufactured

No



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45560

48276

51930

37

1

31

5

1 10/1/14

4 EC 10/2/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:52 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	84.0000	4.0000			



Cross Bolt Spacer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	84	
45338	2	
47657	22	
48277	20	
51932	40	



4 BE 10/01/19

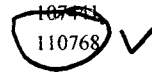
ALS4-1032-225 Purchased No

220 Each 6,691.000 38.0000



Insert

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6691	
10768	16	
110768	6675	



38X M-L 10/01/27

D3492-041 Manufactured No

230 Each 76.0000 8.0000



Plug Assembly

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	76	
51584	76	

55446

8X M-L 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:52 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3		Manufactured	No			230	Each	16.0000	1.0000			

Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	16	
51592 ✓	12	
51903	4	

IX m-k 10/01/27

AN8C35A

Purchased No

230 Each 137.0000 1.0000



BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	137	
102180	1	
106896	1	
110105	48	
110847 ✓	87	

10/01/27  
IX m-k

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:52 AM

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3793-1		Manufactured	No			230	Each	19.0000	1.0000			
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Wearshoe

Warehouse	Location	Loc Qty	Loc Code
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Main Warehouse

ST		19	
40551		1	
51597		16	
51906		2	

10/01/27  
1x m-l

D3488-041		Manufactured	No			230	Each	14.0000	1.0000			
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Blade Fitting Assembly, LH

Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST		14	
47348		14	

~~B 44530~~

10/01/27  
1x m-l

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January 5, 2010 10:43:52 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3		Manufactured	No			230	Each	21.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	18	
51598	6	
51907	12	
Main Warehouse		
ST	3	
46531	2	
47440	1	

W/01/27

IX m-h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:52 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A 		Purchased	No			230	Each	148.0000	4.0000			
BOLT												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	146	
110105	4	
110155	14	
110665	1	
111605	50	
111649	50	
112720	9	
113121	18	

MS21083C8

Purchased

No

230

Each

53.0000

1.0000



NUT

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	53	
110584	5	
111424	2	
112492	6	
113149	40	

January 5, 2010 10:43:52 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 9

January 5, 2010 10:43:53 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25		Manufactured	No			230	Each	40.0000	1.0000			

Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP10

35

51607 ✓

9

54479

26

Main Warehouse

ST

5

45569

1

47011

2

47526

2

D3631-1

Manufactured No

230

Each

442.0000 8.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

442

52693 ✓

142

54388

300

1X m-l 10/01/27

8X m-l 10/01/27

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:53 AM

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3791-1		Manufactured	No			230	Each	11.0000	1.0000			

Wearplate

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

FP

7

51610

7

Main Warehouse

ST

4

51909

4

AN960CI0L

Purchased

No

230

Each

416.0000

38.0000

washer

Warehouse

Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

316

112116

156

112612

160

NAS1149C0332R

QSI 017

M113288

38X

m-l  
10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 11

January 5, 2010 10:43:53 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2745		Manufactured	No			230	Each	346.0000	8.0000			
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Bushing

Warehouse	Loc Qty	Loc Code
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Location

Main Warehouse

ST	59	
----	----	--

34817	2	
-------	---	--

36230	8	
-------	---	--

37303	1	
-------	---	--

39587	2	
-------	---	--

40726	2	
-------	---	--

41114	2	
-------	---	--

42778	6	
-------	---	--

43754	2	
-------	---	--

44893	33	
-------	----	--

45556	1	
-------	---	--

Main Warehouse

ST46	287	
------	-----	--

51537	70	
-------	----	--

51910	36	
-------	----	--

52311	181	
-------	-----	--

8x m-h  
10/01/27

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

January 5, 2010 10:43:53 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			230	Each	609.0000	34.0000			

Bolt

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	113644	
ST	609	
111424	8	
111707	69	
112314	1	
113121	231	
113149	300	

34 x m-l  
10/01/27

D3537-1 Manufactured No

230 Each 141.0000 3.0000



Wearpad

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	139	
51678 ✓	34	
51679	105	

3x m-l  
10/01/27

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:53 AM

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L  WASHER		Purchased	No			230	Each	240.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	240	
104093	2	
107520	4	
110139	29	
110584	100	
111424 ✓	105	

D3492-043

Manufactured No



Plug Assembly

230 Each 143.0000 8.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	123	
54682 ✓	123	
Main Warehouse		
ST	20	
52309	20	

10/01/27  
IX m-l

8X m-l  
10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 14

January 5, 2010 10:43:53 AM

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A  BOLT		Purchased	No			230	Each	828.0000	4.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

828

111982 ✓

828

NAS1611-013

Purchased

No

230

Each

74.0000

8.0000

O-RING

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

74

106513

11

111474

20

111758 ✓

43

4X

M-L  
10/01/27

8X

M-L  
10/01/27

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

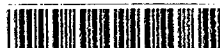


# Picklist Print

Page 15

January 5, 2010 10:43:53 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3535-25 Manufactured No

No

230

Each

15.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

7

51927

7

Main Warehouse

ST

8

52589

8

D3794-1

Manufactured

No

230

Each

15.0000

1.0000



Gasket

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

12

51928

12

Main Warehouse

ST

3

46530

1

47212

2

10/01/27

IX m-d

10/01/27

IX m-d

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 16

January 5, 2010 10:43:53 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6		Purchased	No			230	Each	1,000.000	4.0000			
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1000

111424

8

112314 ✓

992

260

Each

55.0000

2.0000

D3493-1

Manufactured

No



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

55

44002

2

47710

53

10/01/27  
m-l  
4x  
10-1-29 sp

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 10:43:53 AM

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S MS21083C8 NUT		Purchased	No			260	Each	53.0000	2.0000		10-1-29	SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	53	
110584	5	
111424	2	
112492	6	
112149	40	

S AN8C21A BOLT		Purchased	No			260	Each	148.0000	2.0000		10-1-29	SP
-------------------	--	-----------	----	--	--	-----	------	----------	--------	--	---------	----

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	148	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
112720	38	
113358	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 18

January 5, 2010 10:43:53 AM

Work Order ID: 54953

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C816L

Purchased

No

260

Each

240.0000

2.0000

WASHER

10-1-29

sl

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

240

104093

2

107520

4

110139

29

110584

100

111424

105

2

D3672-1

Manufactured

No

230

Each

1,744.000

4.0000

Phenolic Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1244

39275

19

42329

5

47628

220

52305

1000

Main Warehouse

ST117

500

51674

500

10/01/27

4X

m-l

January 5, 2010 10:43:53 AM

Shop Packet Print

Page 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January 5, 2010 10:43:53 AM

Work Order ID: 54953



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741

Manufactured

No

260

Each

45.0000

1.0000



Blade, 350 Skidtube

10-1-29

SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

45

45320

1

47113

4

51931

40

D3532-1

Manufactured

No

260

Each

80.0000

2.0000



Spacer

10-1-29 SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

80

44904

2

52321

78

D3672-13

Purchased

No

260

Each

948.0000

2.0000



Phenolic Washer

10-1-29 SP

SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

948

54363

948

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3751-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225 AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN305A	BOLT
4	4	4	4	AN306A	BOLT
4	4	4	4	AN5C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21053C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54933  
B-10-1-05

RELEASED  
# 10-1-05

# GENERAL NOTES:

MATERIAL: MAKE D2750-1/2/3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS

WELD PER DART QSI 004

INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL F" SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS

3) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI

1) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF

POWDER COATING WITH MEK DEGREASER

2) SPACER AND PLUG INSTALLED SAME AS SECTION A1-A1 EXCEPT HORIZONTAL

3) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 8413; QTY (3) D5537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN C8-1); ADD D3751-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/FT SADDLE REMOVED (6 PL). WEARSHOE HARDWARE QTY UPDATED (ZN C8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-2, 8, 10, 14); ADD NOTE 12 AND 13 (ZN A5-1); REASON: REF. NCR 08-043	PH	08.07.15
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS. CHANGE INSERTS. ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (12) NAS1515H8L; REMOVE D2741; QTY (2) AN960C815; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	Ph	05.01.05
C	ADD D2750-2/D2750-4; INCORPORATE D2726 AND D2740	CP	08.11.18
B	CHANGE MS24694-S253 TO AN6-16A	CP	02.05.01
A	NEW ISSUE	DS	08.04.15
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA	DATE	08.07.16
DRAWN	PORT HADLOCK, WA	DATE	08.07.16
CHECKED	DART AEROSPACE USA, INC.	DATE	08.07.16
MFG. APPR.	DART AEROSPACE USA, INC.	DATE	08.07.16
DE APPR.	DART AEROSPACE USA, INC.	DATE	08.07.16
DATE	08.07.16	DATE	08.07.16

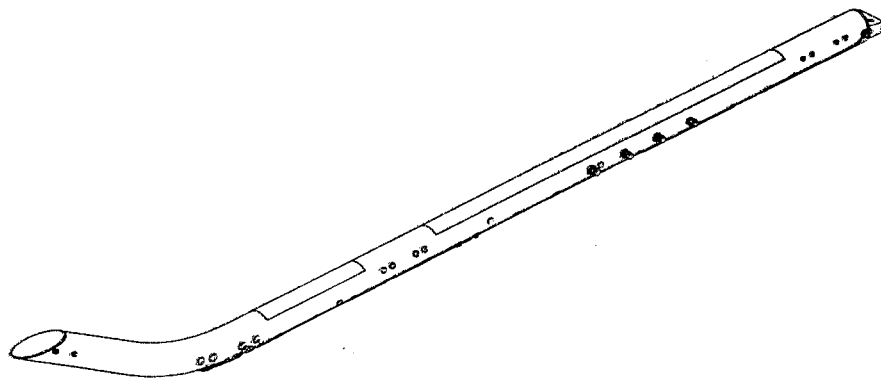
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

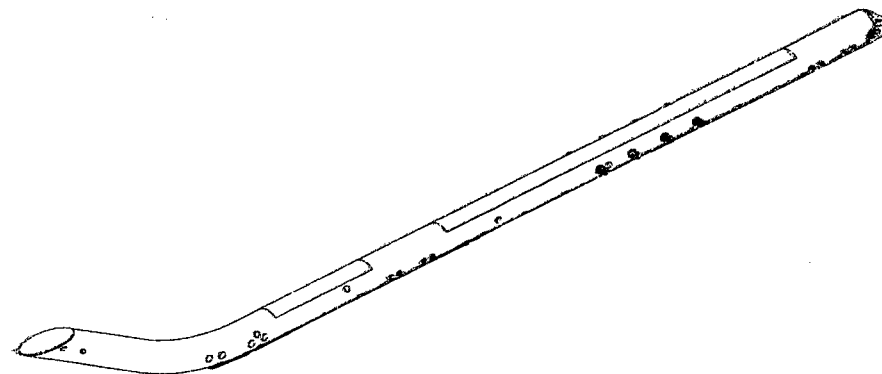
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
SEP 12 1970

W/D 54953

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HAZARD, WA	
CHECKED	[Signature]	DRAWING NO.	REV. F
MFG. APPR.	[Signature]	D2750	SHEET 2 OF 11
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	350 SKIDTUBE ASSEMBLY	NTS
DATE 08.07.16		<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED BY THE ENTIRE CORPUS THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER CORPUS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

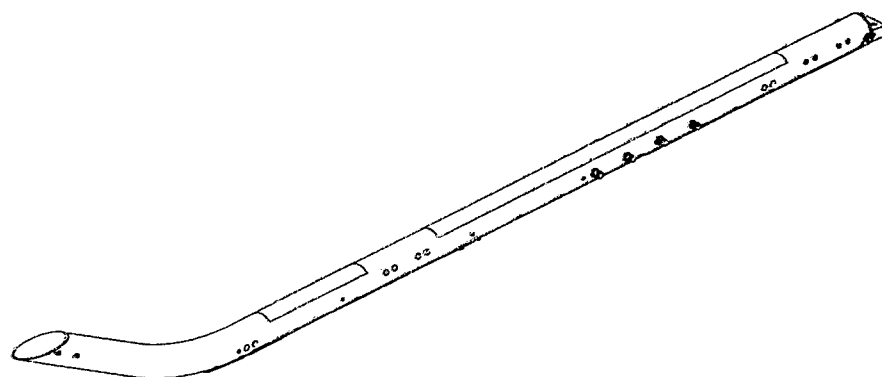
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

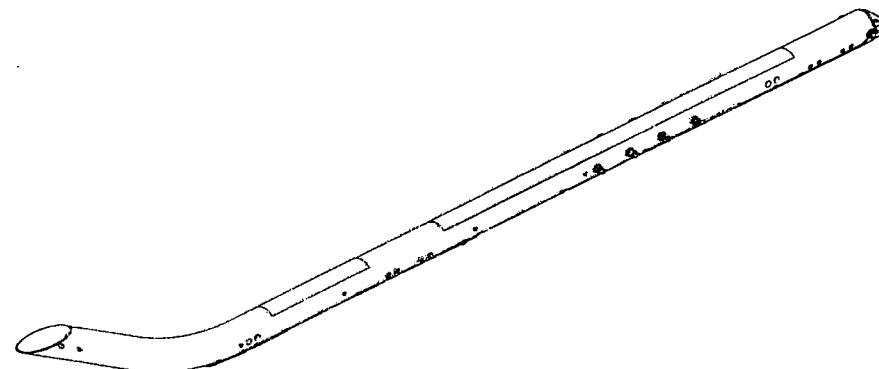
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-9-22/100

W/0 54953

DESIGN	10	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	10	PORT HADLOCK, WA	
CHECKED	10	DRAWING NO.	REV. F
MFG. APPR.	10	D2750	SHEET 3 OF 11
APPROVED	10	TITLE	SCALE
DE APPR.	10	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

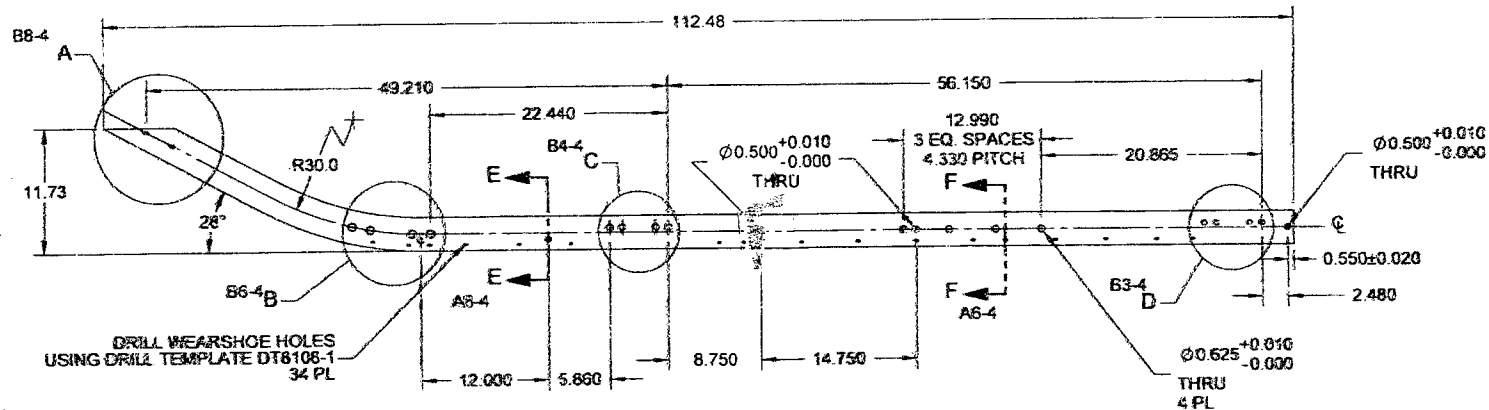
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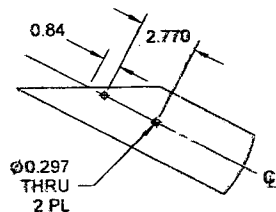
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

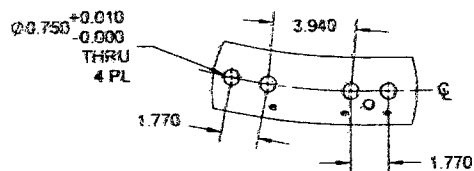




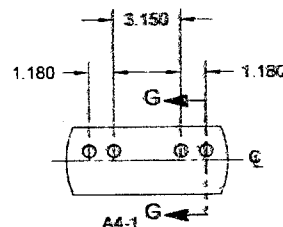
**D2750-1 LH SKIDTUBE**



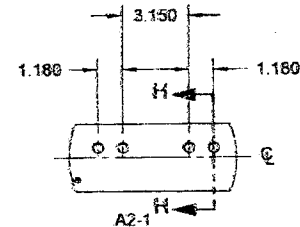
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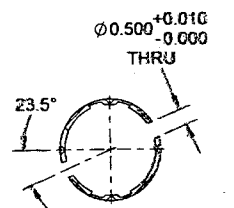
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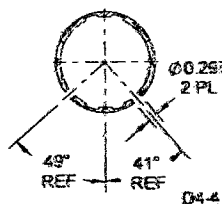
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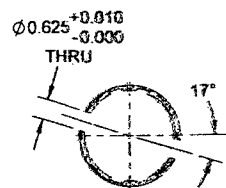
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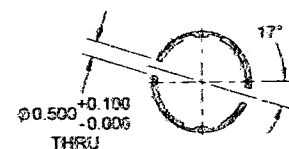
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**

w/0 54953

DESIGN	DATE	DART AEROSPACE USA, INC.	REV. F
DRAWN	08.07.16	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	SHEET 4 OF 11
MFG APPR.		TITLE	SCALE
APPROVED		350 SKIDTUBE ASSEMBLY	NTS
DE APPR.			
DATE	08.07.16		

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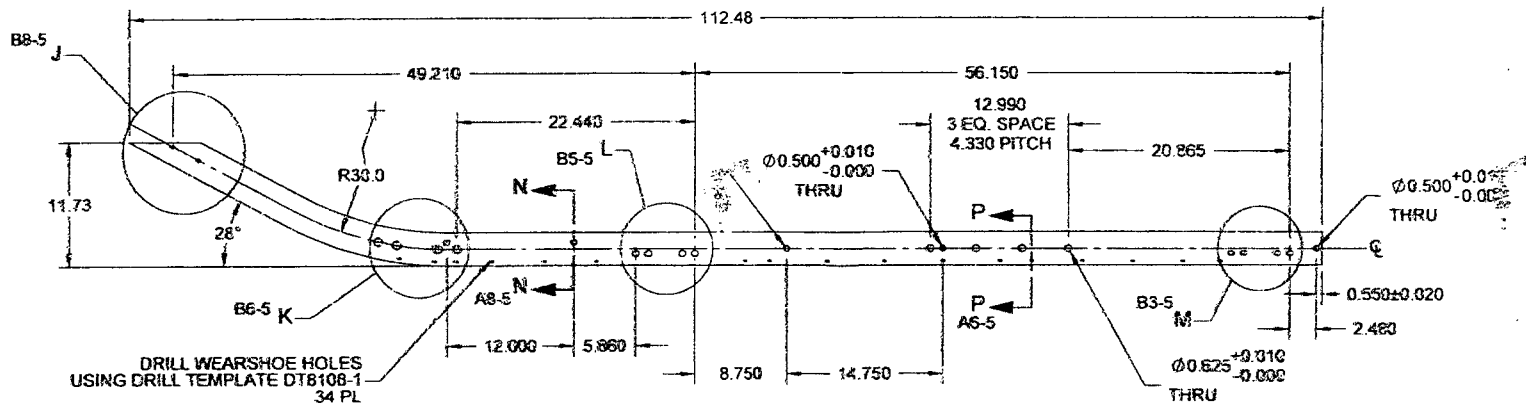
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

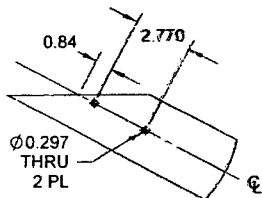
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

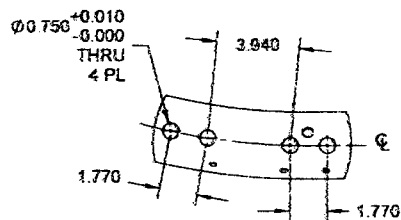
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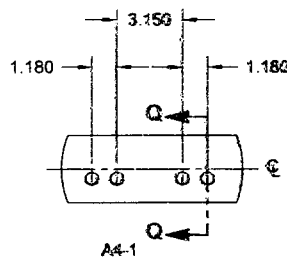
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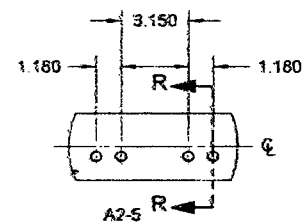
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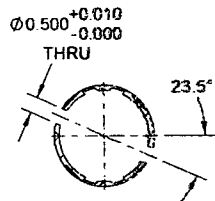
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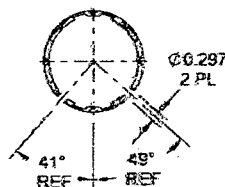
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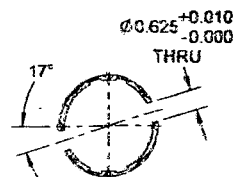
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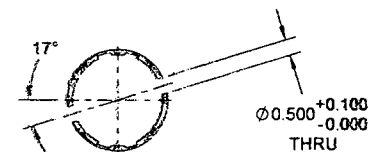
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

Ø0.500<sup>+0.100</sup>  
-0.000  
THRU

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6-9-21

W/0 54953

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC.	
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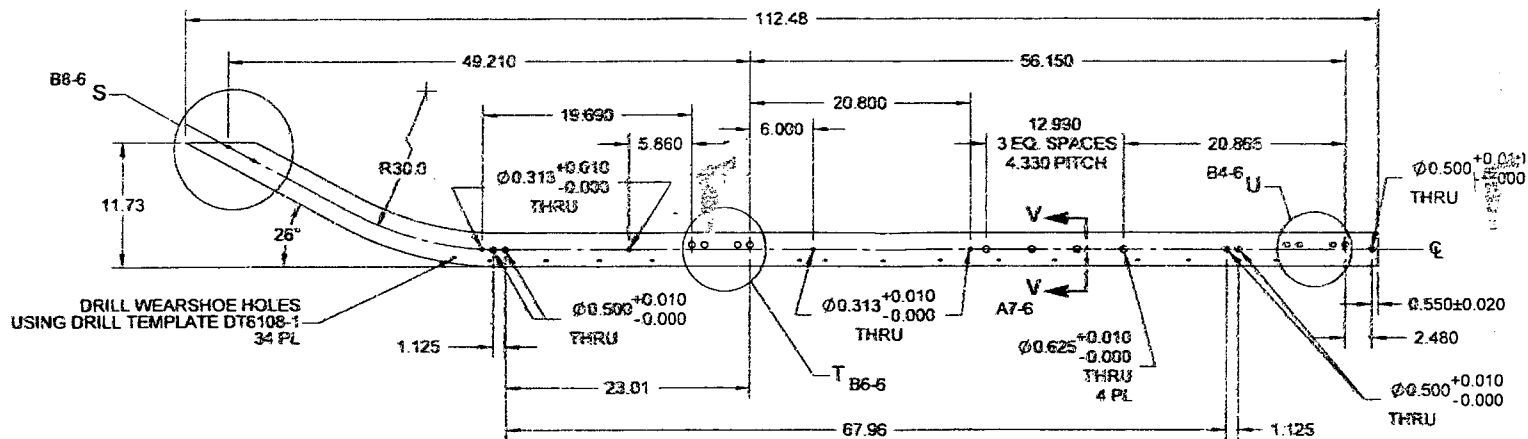
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

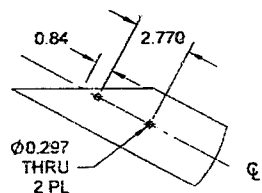
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

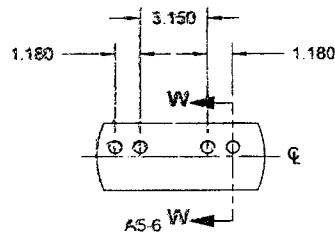
**NOTE:** Date & initial all entries



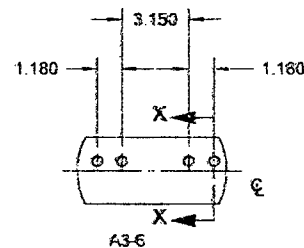
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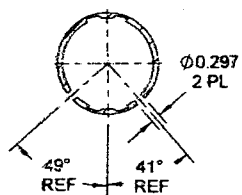
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SCALE 2X



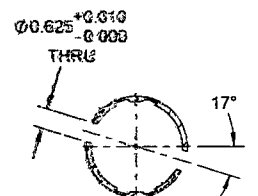
**DETAIL T**  
SCALE 2X



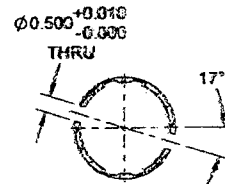
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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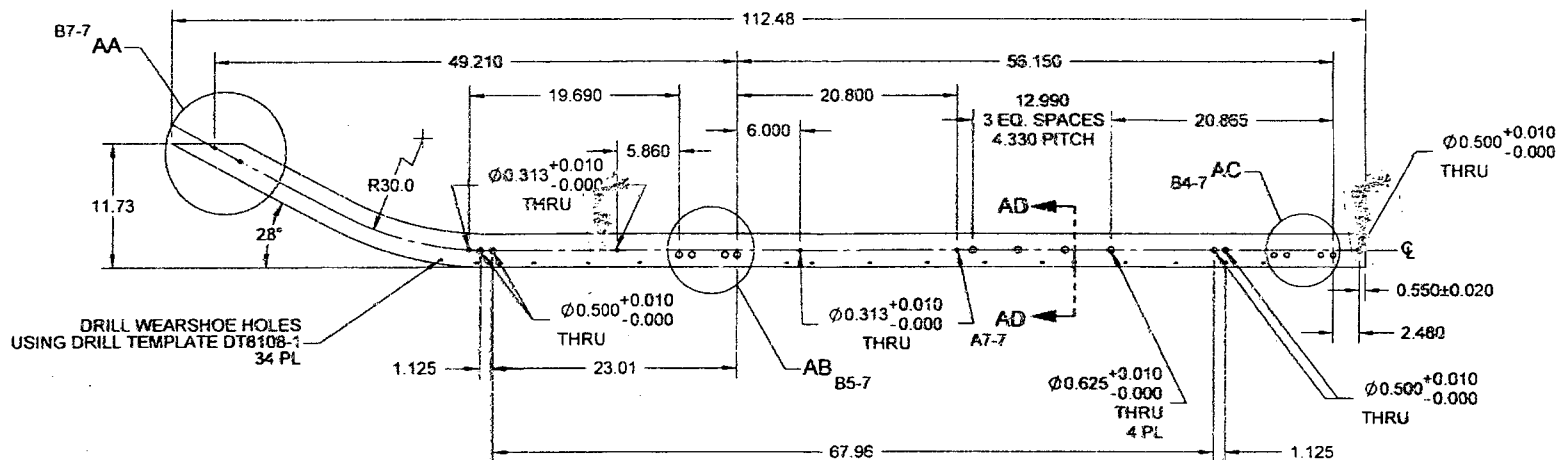
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

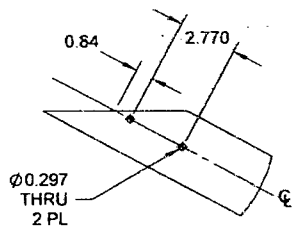
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

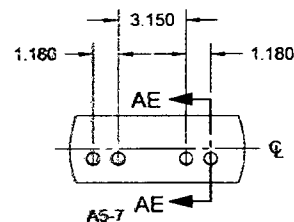
**NOTE:** Date & initial all entries



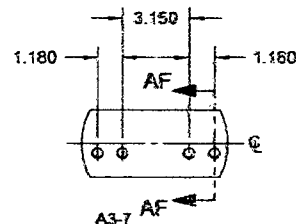
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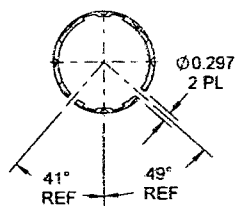
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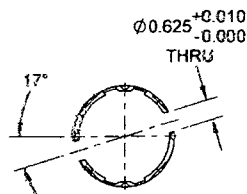
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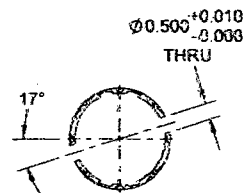
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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DESIGN	WLD 54953	DART AEROSPACE USA, INC.	REV. F
DRAWN		PORT HADLOCK, WA	
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DE APPR.			
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





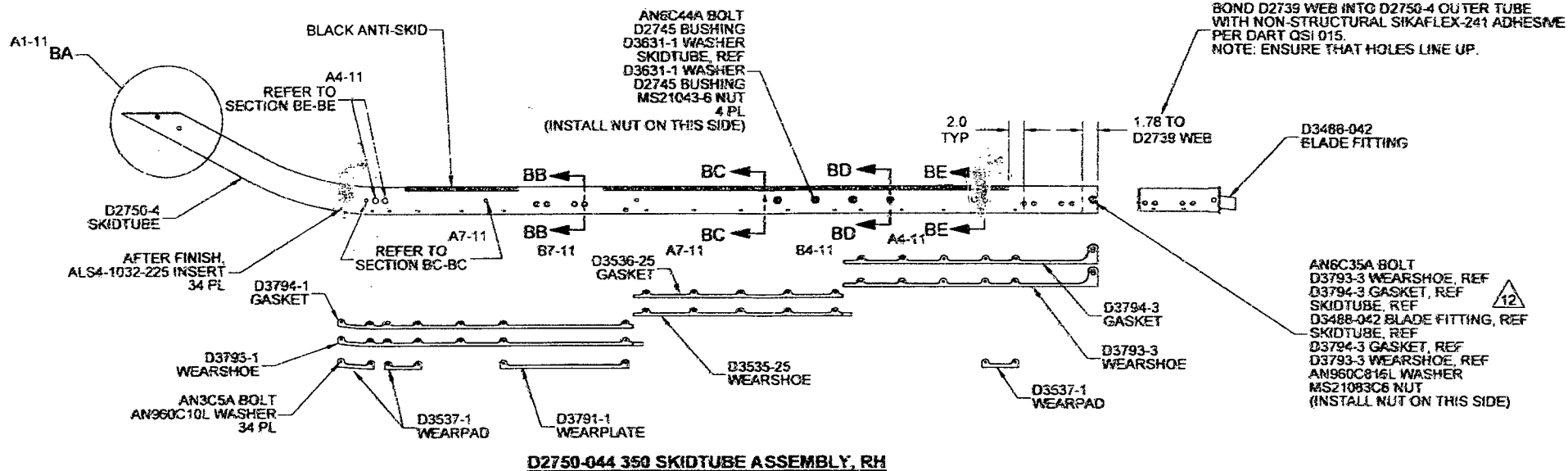
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

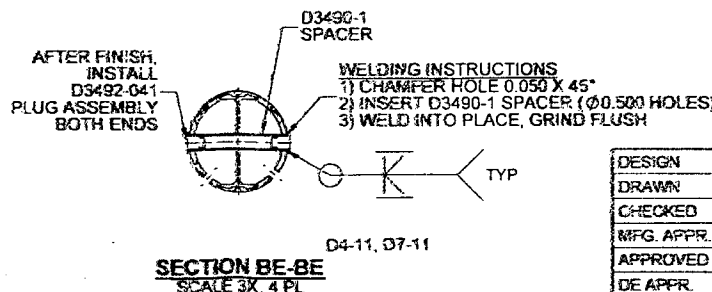
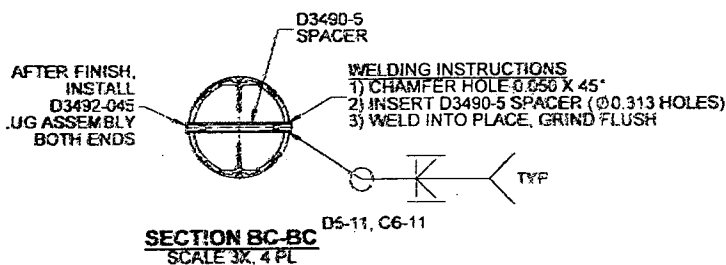
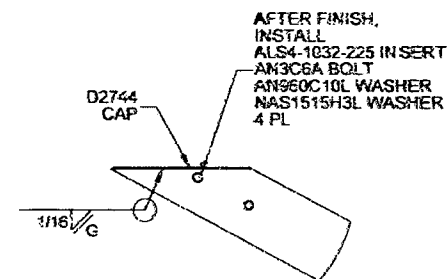
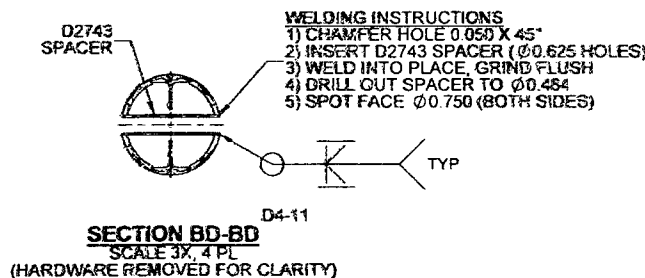
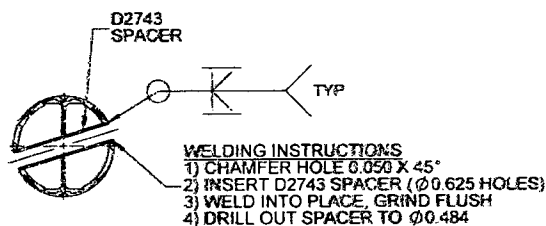
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DESIGN	W/054953	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		D2750	SHEET 11 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 222

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 54986  
Part number: D350-636 012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[ ] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier [Signature] Date of Test Coupon 10-01-11

Welder Barclay Elliott Date of Test Coupon 10-01-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld